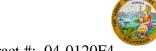
DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-000533 Address: 333 Burma Road **Date Inspected:** 26-Sep-2007

City: Oakland, CA 94607

OSM Arrival Time: 1400 **Project Name:** SAS Superstructure **OSM Departure Time:** 2300 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name: Xu Liang Zhang & Li Wen ShengCWI Present: Yes No

Inspected CWI report: Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes No N/A **Approved Drawings:** Yes No **Approved WPS:** Yes No N/A

Delayed / Cancelled:

34-0006 **Bridge No: Component:** 114

Summary of Items Observed:

On this date, Caltrans Office of Structural Materials (OSM), Quality Assurance (QA) Inspector, David A. Smith was present for the observations related the following;

Item-1 114 Skin-D, Upper section. In progress was the grinding and dressing of the completed cover pass welds at the ends of the stiffener plates.

Item-2 114 Corner section, B side, plate #P858, TA119 and P927. Filler pass welds being performed by welding operator (A) Wen Vanyan #066734 and (B) Cao Henjin #66420 both certified with Flux Core Arc Welding (FCAW) in the 3G position. Welding parameters recorded by this QA Inspector were, welder (A) #1 weld, Amps was 300, Volts 30.5 and a travel speed of 305 mm/min and welder (B) weld #2, Amps was 298, Volts 30 and the Travel Speed was 294 mm/min. The welding procedure used was WPS-B-T-2231-TC-U5-F. The ZPMC QA was Fu Yuhong, QC Zhang Qiao and CWI Xu Liang Zhang and Li Wen Sheng were present performing visual observations.

Item-3 114 Corner section, plate #P918 to A116, 345 material. Filler passes being added to weld #1 on A side by welder operator Jiang Zhou #040261. Welding parameters recorded by this QA Inspector were, Amps was 330, Volts 32 and the Travel Speed was 324 mm/min. The welding procedure used was WPS-B-T-2231-TC-U5-F. The attending CWI was Xu Le Feng.

Summary of Conversations:

There were no pertnent conversations pertaining to the project during this shift.

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials

WELDING INSPECTION REPORT

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for your project.

Inspected By: Smith,David Quality Assurance Inspector

Reviewed By: QA Reviewer Cochran,Jim